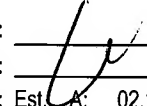
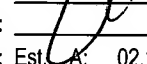


Date: Monday, 9/22/2008 11:17:29 AM  
User: Chantal Lavoie

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STEP EXTRUSION
<b>Job Number</b> :	42155		
<b>Estimate Number</b> :	10058		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2622120C
<b>This Issue</b> :	9/22/2008	<b>S.O. No.</b> :	
<b>Prst Rev.</b> :	NC	<b>Drawing Number</b> :	D2622 REV C1
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	40937	<b>Drawing Revision</b> :	C1
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	10/15/2008
<b>Comment</b> :	Est. A: 02.11.12 New Issue KJ/RF	<b>Qty:</b>	120 / 110 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: 7222

- a) Extrude as per Dwg D2622 Rev. C
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" long) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

C208/09/22

(110) 120

2.0	D2622120CP	Extrusion
-----	------------	-----------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 110.0000 Each(s)  
Extrusion

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage  
Ensure material certification is attached

R 8/10/10

(126)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

Inspect dimension per Dwg D2622  
Check Pull test per Dwg D2622 for compliance page attached  
Check hardness with Webster tester

S 08/10/17 (126) counter

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 9/22/2008 11:17:29 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 42155

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

HALL (3)

98

G.A

28

→ 08/10/21

Am  
(126)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

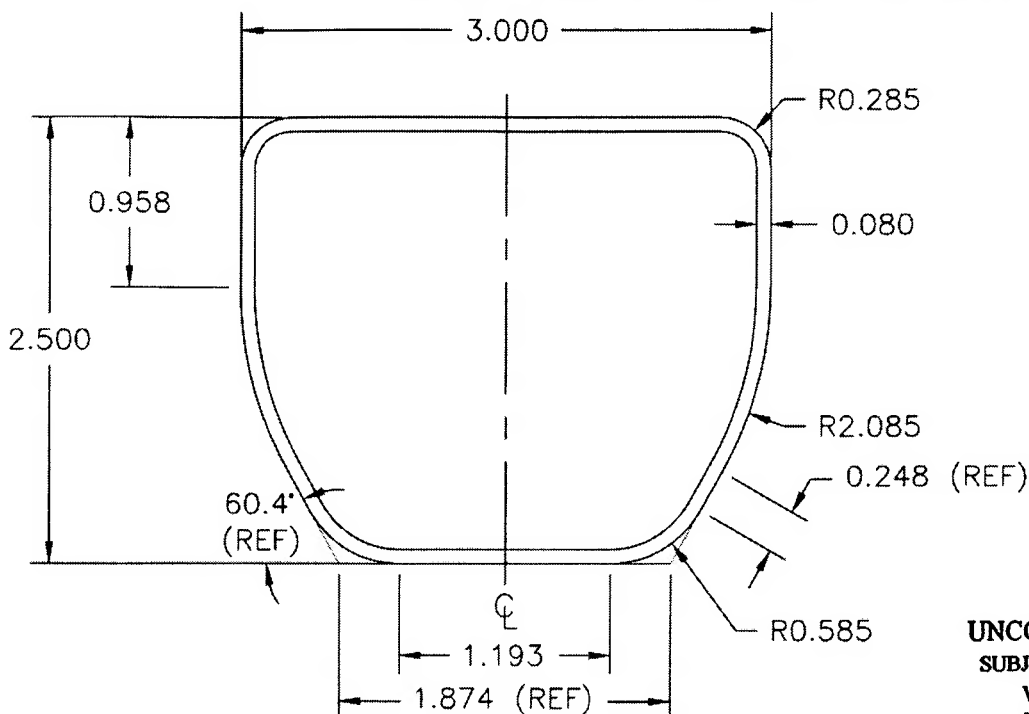
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	KE	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE	02.09.11			TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29			NEW ISSUE	
B	97.12.12			CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11			0.080 WAS 0.085; ADD PART & DIE No.	
C1	#	UP	02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED  
02.09.11 #



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42155

#### D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES  
(EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

INVOICING COMPANY AND LOCATION  
SIGNATURE ALUMINUM CANADA  
500 EDWARD AVENUE  
RICHMOND HIL ON L4C 4Y9

**SHIPPING MANIFEST**

ACCT# 00046024

MANIFEST DATE	10-15-08
MANIFEST NUMBER	649044
SALES ORDER NUMBER	37418

REFER TO  
THESE NUMBERS ON  
ALL CORRESPONDENCE

CREDIT REP  
HAMBROOK, PAU  
905-508-3250

SALES REP

FIELD SALES REP  
Kutter A  
450-435-6551

CUST SERVICE REP  
Burton D  
905-427-2227

TERMS / FREIGHT  
O / P

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN
PHONE 613-632-5200	PHONE 613-632-5200

LOCATION RIH	TRAILER NUMBER 57382	SALESMAN 59358
-----------------	-------------------------	-------------------

CUSTOMER ID 46024	ORDER DATE 09/22/08	CUSTOMER PO NUMBER 7222
----------------------	------------------------	----------------------------

JOB	BILL OF LADING NUMBER 08384417
-----	-----------------------------------

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE
				CUSTOMER PART NUMBER	LENGTH CUTTING TOLERANCE	FABRICATION DESCRIPTION SHIPPING TOLERANCE	NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
01	121	KG	0	DAA-897123-1	6061 /T6	MILL	3	552	518	KG	0
		M	0	D2622	120"	CERTIFICATE OF COMP			384.05	M	0
		PC	0		+3/16 "	(+015-015,0139-0102)			126	PC	0
					-0 "						
				DO NOT PRE-SHIP							
				LOT/TKT DETAIL:							
						37418010 / 198763	1	184	170		42 PC
						37418010 / 198788	1	184	174		42 PC
						37418010 / 198790	1	184	174		42 PC
											126

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.  
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

3	552	518	KG
		384.05	M
		126	PC
TOTALS			

# CERTIFICATE OF COMPLIANCE

## SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE  
RICHMOND HILL, ON L4C 4Y9

Cert. Date	Cert. No.	Sales Order	Page
10/15/08	182890	37418	1
Cust. PO	B/I. No.	Lot	Date
7222	08384417	37418010	10/15/08

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622

Gross Weight	552 KGS
--------------	---------

Net Qty	518 KG	126 PC	384 M	3 PKG
---------	--------	--------	-------	-------

Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-08	

### Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	314.5 / 45.6	278.0 / 40.3	13.6	.0	95

### Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.65	.30	.23	.04	.87	.05	.006	.03	.000	.010	.02	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

*08/10/07*

D. VanBakel, QA Manager Signature Aluminum Canada Inc